



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 171674



Part No: D350-591-311

Job Qty: 6 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/9/18	0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	6 pcs		2/9/18	0.00	5.95	Large Fab 2		SL
120	QC	6 pcs		2/9/18	0.00	0.00	QC9		PO 18-02-09
130	QC	6 pcs		2/9/18	0.00	0.00	QC5		PO 18-02-09
140	HandFinish	6 pcs		2/9/18	0.00	1.10	HandFinish1		18-02-12
150	QC	6 pcs		2/9/18	0.00	0.00	QC7-2		CPC
180	Large Fab	6 pcs		2/10/18	0.00	5.95	Large Fab 2		SL
190	QC	6 pcs		2/10/18	0.00	0.00	QC10		CPC
200	QC	6 pcs		2/10/18	0.00	0.00	QC5		CPC
210	HandFinish	6 pcs		2/10/18	0.00	1.10	HandFinish1		18-02-13
220	Powdercoat	6 pcs		2/10/18	0.00	1.74	Powdercoat1		BR 18-02-20
230	HandFinish	6 pcs		2/12/18	0.00	1.10	HandFinish3		BEB 18-02-21
240	QC	6 pcs		2/12/18	0.00	0.00	QC3		38
250	Packaging	6 pcs		2/12/18	0.00	0.00	Packaging1-3		SH 9-89
260	QC	6 pcs		2/12/18	0.00	0.00	QC4		17.10
265	DC	6 pcs		2/12/18	0.00	0.00	DC		17.10
270	Packaging	6 pcs		2/12/18	0.00	0.00	Packaging3-1		17.10
280	QC21-FG	6 Ea		2/12/18	0.00	0.00	QC21		21 FEB 23 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per DWG.

220 - START TIME: 5:00 OVEN TEMPERATURE: 320 FINISH TIME: 5:30

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

Wing walk M138761

G01087

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																				
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																				
Description Work Order Deviation		Disposition																																						
Job No: 171674 Mfg Date: 02/07/18 CHG002 Packaging Operation: Revision: Serial No/Batch: S040275 PART NO: D350-591-311 Float Compatible Helix Access - Step LH - High Gear, Long Step, Aerazur		Change No: Operation: Revision: Serial No/Batch: S040275 PART NO: D350-591-311 Float Compatible Helix Access - Step LH - High Gear, Long Step, Aerazur																																						
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	6 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	12 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	6 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	6 Ea (1 ea)	180-Large Fab	5040086
D3066-1	Spacer	12 Ea (2 ea)	180-Large Fab	5036202
D3067-1	End Plate	6 Ea (1 ea)	180-Large Fab	5034373
MS20600-AD4W4	Rivet	96 Ea (16 ea)	180-Large Fab	5034396
AN3-35A	Bolt	12 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	48 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	12 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	24 Ea (4 ea)	250-Packaging	
D2618	Bushing	12 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	12 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	12 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	6 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	12 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	48 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	12 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	24 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	96 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	24 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	6	91	0
	D3219-1	12	98	0
	D3272-1	6	10	0
180-Large Fab	D3065-041	6	2	0
	D3066-1	12	90	0
	D3067-1	6	91	0
	MS20600-AD4W4	96	1,321	0
250-Packaging	AN3-35A	12	164	0
	AN4-13A	48	618	0
	AN5-36A	12	90	0
	D2230-3	24	133	0
	D2618	12	36	0
	D2856-400-720	12	145	0
	D3235-1	12	6	0
	D3278-041	6	21	0
	MS21042L3	12	3,805	0
	MS21042L4	48	1,991	0
	MS21042L5	12	501	0
	NAS1149D0363J	24	3,717	0
	NAS1149D0463J	96	3,420	0
	NAS1149D0563J	24	1,501	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

DISPOSITION

 Rework ☐
 Scrap ☐
 e-as-is ☐
 roved ☐

 Skid-tube ☐
 Machining ☐
 Thermoforming ☐
 Large Fab ☐

AGAINST DEPARTMENT/PROCESS

 Cross tube ☐
 Small Fab ☐
 Finishing ☐
 Composite ☐

 Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

 Engineering ☐
 Quality ☐
 Other ☐

QTY Effective : _____

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
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 Heli - Access - Step LH - High Gear, Long Step, Aerazur
 Float Compatible

PART NO: D350-591-311

Original Serial #: S040275

Revision:

Operation:

Change No:

Start up Operation 02/07/18

Job No: 171674

CHG002



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 001087

Tel (613) 632-5200

Containers on Master Unit 001087				
Serial No	Part No	Customer Part No	Status	Quantity
S044322	AN3-35A		Allocated	12
S044321	AN4-13A	AN4-13A	Allocated	48
S044320	AN5-36A	AN5-36A	Allocated	12
S044319	D2230-3	D2230-3	Allocated	24
S044317	D2618	D2618	Allocated	12
S044316	D2856-400-720	D2856-400-720	Allocated	12
S044315	D3278-041	D3278-041	Allocated	6
S044314	MS21042L3	MS21042L3	Allocated	12
S044312	MS21042L4	MS21042L4	Allocated	48
S044311	MS21042L5	MS21042L5	Allocated	12
S044310	NAS1149D0363J	NAS1149D0363J	Allocated	24
S044309	NAS1149D0463J	NAS1149D0463J	Allocated	96
S044308	NAS1149D0563J	NAS1149D0563J	Allocated	24

QC4 D2230-1 X12 S044304

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]